Work Orde		775		*837	775*		. :			Page 1
Revision ID:	D350-591-312 Heli-Access-Sto	. :		Accept	*N9000	40100	<b>)*</b> s	etup Start Stop	i Vi c	S1*
Start Date: Required Date: Reference:	25/04/2012 25/06/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:		-pr		IVI	
Approvals:	Process Plan	n: MLJ	Date: 12/64	2 ØTooling: SPC (Y/N):	Date:		R	un Start Stop	*NF *NF	R1* R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID To	ool# Plan Code	Accept Qty		Reject Number	Insp. Stamp
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D3272 100 *100* DC Document Control	Rev I	DOCUMENT CONTR	,	0.00 0.00 as per PPP D350-591-312 (	CHG001 8,7 octo	. <u>.                                   </u>	H	for m	1LJ 1	2-6-13 3
*110 * Large Fab		Large Fab  Memo 1-Bevel en	d for welding FWD ONI	0.00 0.00			_5_	d d	· · · · · · · · · · · · · · · · · · ·	12.05.1
`		2-Weld Suj D3272 A/R Alu		weld Fwd End Plate as per (	QSI 004 & Dwg				7) (1) 7) (2)	He.

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April-25-12 10:13:09 AM Item ID: D350-591-312 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Heli-Access-Step, Long RH **Start Date:** 25/04/2012 Start Qty: 5.00 **Cust Item ID: Required Date: 25/06/2012 Req'd Qty:** 5.00 **Customer:** Reference: Run Process Plan: Date: \_\_\_\_\_ Approvals: **Tooling:** Date: QC: \_\_\_\_ Date: \_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qtv Number Stamp 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 \*120\* QC 0.00 Memo Quality Control 130 QC5- Inspect part completeness to step on W/O 0.00 \*130\* S 17/06/05 QC Memo Quality Control - - 140 Chemical Conversion Coat per QSI005 4.1 0.00 \*1**4**0\* HandFinish 0.00 Memo

Hand Finishing

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April-25-12 10:13:09 AM Item ID: D350-591-312 Accept \*N900040100\* Setup Start **Revision ID: Item Name:** Heli-Access-Step, Long RH **Start Date:** 25/04/2012 Start Qty: 5.00 **Cust Item ID: Required Date: 25/06/2012 Req'd Qty:** 5.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool# Reject Set Up/ Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp-150 QC3- Inspect Part Finish 0.00 \*150\* QC 0.00 Memo Quality Control 180 0.00 Large Fab \*120\* Large Fab 0.00 Memo Large Fab 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod /20854 12.06.11 6-Grind End Plate flush

7-Install last rivet as per Dwg.

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Item ID: Revision ID:	D350-591-3	12		Accept	*N900	040	100	)*	Setup St	11	JS1*
Item Name:	Heli-Access-S	Step, Long RH							St	op *\	<b>IS2</b> *
Start Date:	25/04/2012	Start Qty: 5.00	*5*		Cust Item I	D:					
Required Date: Reference:	: 25/06/2012	Req'd Qty: 5.00	*5*		Customer:						
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	QC:	· · · · · · · · · · · · · · · · · · ·	Date:	SPC (Y/N):	Da	ate:			St	op */	IR2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description QC10- Inspect visual pe	r QS1004- ground welds	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
*190* QC Quality Control		Memo		0.00 Tlake	112						
200		QC5- Inspect part comp	leteness to step on W/O	0.00					•		
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<sup>210</sup> *210*	م م	Chemical Conversion Co	pat per QSI005 4.1	0.00				5	$Q_{\mu}$	6 1	06-12
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Memo

Hand Finishing

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Work Orde		775		*837	775*			Page 5
Revision ID:	D350-591-31		- <del>12</del> .1.2 <u>- 1</u> 2.1.3 - 12.2.3 - 12.2.3 - 12.2.3	Accept	*N90004010	ገበ* Se	tup Start Stop	*NS1* *NS2*
Start Date: 2 Required Date: 2 Reference:	25/04/2012 25/06/2012	Start Qty: 5.00 Req'd Qty: 5.00	• •		Cust Item ID: Customer:			14.37
	Process Plan:  QC:		Date:		Date:	Rı 	ın Start Stop	*NR1* *NR2*
		Operation Description White Gloss(Ref:4.3.5.1) per QSI005 4.3  Memo START TIME: OVEN TEMPERATURE: FINISH TIME: Wing Walk as per dwg QSI005 4.4 Batch		Set Up/ Run Hours 0.00 0.00 23 · 0.00	Tool ID Tool # Pla Coo	-		Reject Insp. Number Stamp  12/06/
HandFinish Hand Finishing		Memo		0.00		5 9		J41610.
240 * <b>210</b> *		QC3- Inspect Part Finish		0.00		504	F	H what is

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Memo

Quality Control

## **Dart Aerospace Ltd** W/0: **WORK ORDER CHANGES** Approval **Approval** DATE STEP PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval STEP** DATE Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

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Revision ID:	D350-591-3 Heli-Access-S			Accept	*N900	<b>1</b> 040		<b>)</b> *	Setup Sta	1 7	S1* S2*
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	QC:			•		Date:			Sto	<sup>p</sup> *N	R2*
Sequence ID/ Work Center II 250	)	Operation Description Pick Kit		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*250* Packaging Packaging		Мето		0.00				_5		<u> </u>	12/06/13
<sup>260</sup> *260*		QC4- 100% Inspect kits	for completeness	0.00	1 —					•	
QC Quality Control		Memo		0.00	(1)			9			

270

\*270\*
Packaging

Packaging

Packaging

Identify and pack for shipping as per PPPD350-591-312 Location:

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Work Order ID 83775  April-25-12 10:13:09 AM			*83775*								Page 7	
Revision ID: Item Name:	D350-591-31 Heli-Access-S 25/04/2012	2	*5* *5*	Accept	*N900  Cust Item I  Customer:		110(	)*	Setup	Start Stop	*NS	S1* S2*
Approvals:	Process Pla QC:		Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop	*NF	R1* R2*
Sequence ID/ Work Center ID 280 *280* QC Quality Control	)	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		6/18	Insp. Stamp

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Page 1

Work Order ID: 83775

\*83775\*

D350-591-312

\*D350-591-312\*

Parent Item:

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

**Required Date: 25/06/2012** 

Start Qty: 5.00

Required Qty: 5.00

**Comments:** 

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

fixe route seq in bom DD 10.04.28 verified by:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 *\bigcap_3272-1* Step		Manufactured	No		=	110	Each	20.0000	**	5	Sell	1 2.05.	23
				Location	1	Loc	<u>Qty</u>	Loc Code					
				ST WA	B83777	<del></del>	-10 30		_	5	_		
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D3067-1 *D3067-1*		Manufactured	No			110	Each	187.0000	1 **	5	_	1	

*D3067-1	*
End Plate	

Loc Oty	Loc Code
123	
4	
45	
74	
64	
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	Loc Qty 123 4 45 74 64 2 1

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	Work Order ID: 83775  Parent Item: D350-591-312  Parent Item Name: Heli-Access-Ste	an Love DII		3775* 350-591 <b>-</b> 3	12*					· · · · · · · · · · · · · · · · · · ·	
	Tarent Item Name. Hen-Access-ste	p, Long Kn						tart Date: 2 Start Qty: 5		Required Date Required Qty	
	D3065-041	Manufactured	No		180	Each	19.0000	1	5		
•	*D3065-041* Step Leg Assembly Hi							**	8838	<sup>2</sup> 70 →	3
				<b>Location</b>	Loc	<u>Oty</u>	Loc Code		B 808	380 <del>-&gt;</del>	2 12.06.0
				WA		19				Ae	12.06.0
				66149 78798		0 18			-		
				79336		1					
\	D3067-1	Manufactured	No		180	Each	187.0000	1	5	11/	
	*D3067-1* End Plate							**		1212.06	.08
				Location	Loc	<u>Qtv</u>	Loc Code				
				WA <u>383855</u>		123					
				78608 80881		4 45					
				81969		74					
				WA016		64					
				675,82		2					•
				68214 79607		1					
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				ST353		127					
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120717

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**Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval Approval** STEP DATE **PROCEDURE CHANGE** By Qty Chief Eng / Date QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A QC Inspector Section C Chief Eng Date Chief Eng Chief Eng

April-25-12 10:13:14 AM

Work Order ID: 83775 \*83775\* Parent Item: D350-591-312 \*D350-591-312\* Parent Item Name: Heli-Access-Step, Long RH **Start Date: 25/04/2012 Required Date: 25/06/2012** Required Oty: 5.00 Start Qty: 5.00 D3235-1 Manufactured No 250 Each 39.0000 \*\* Mounting Lug Location Loc Qty Loc Code ST 39 78787 39 D3278-041 Manufactured No 250 68.0000 Each Loc Qty Location Loc Code ST471 78795 3 ST481 65 82015 40 83361 25 AN960JD416 Purchased No 250 Each 10.0000 Location Loc Qty Loc Code ST351 10 116289 10 NAS1149D0563J Purchased No 250 0.0000 Each

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Work Order ID: 83775

\*83775\*

Location

No

Parent Item:

D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

**Required Date: 25/06/2012** 

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

250

Loc Qty

Each 156.0000

Manufactured No 340 100 121181 100 ST340 56 120187 6 120731 50 250 Each

190.0000

Loc Code

D2230-3

Manufactured No Location Loc Qty Loc Code ST012 190 76130 2 80474 188 250 87.0000 Each

Location Loc Qty Loc Code ST480 87 53881 70973 81558 82

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Work Order ID: 83775

Parent Item:

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

\*83775\*

\*D350-591-312\*

Start Date: 25/04/2012

**Required Date: 25/06/2012** 

Start Qty: 5.00

Required Qty: 5.00

\*D2856-400\*

Abrasion Strip

D2856-400

Manufactured

250

335.5345

Loc Code

1.2

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Purchased

No

Location Loc Qty ST403 216 81875 216 ST409 119.5345 63735 0.6696 68076 0.3149 71164 8.46 79551 110.09

250

Each

81875

<b>Location</b>	Loc Oty	Loc Code	
ST300	3434		
117441	16		
117885	32		
118451	5		
118927	3		
119017	1340		
119075	158		
121349	880		121349
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AN960JD10 NAS1149D0363J Purchased \*\* AN960.ID10\*

116188 5
119017 4
119075 805
121011 2000
121444 3000
250 Each 0.0000

4 20 ×\*

121524 gB 12/06/13

No

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DATE	≣ S1	ГЕР	PRO	OCEDURE CHAN	EDURE CHANGE			e Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		i							,	
Part i	No:		PAR #:	Fault Categ	jory:	NCR: Yes	No	DQA:	_ Date: _	
		Resc	lution:	Disposition	n:	QA: N/C C	losed:	•	Date: _	
NCR:			,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
			Description of NC		Corrective Action Section		V	erification	Approval	Approva
DAT	ES	TEP	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		Section C	Chief Eng	QC Inspecto
							_	· · · · · · · · · · · · · · · · · · ·		<del> </del>



	DESIG	"A	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
ļ	CHECKED APPROVED		APPROVED	DRAWING NO.	RĘV. B
		E	世	D3272	SHEET 1 OF 3
	DATE			TITLE	SCALE
	07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
	Α		04.03.01	NEW ISSUE	
	В		07.05.18	D3272-1 WAS D2622-120	

OT OF OH

QTY -041	QTY -042	PART NUMBER	DESCRIPTION					
X			STEP ASSEMBLY, HIGH LONG (LH)					
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)					
1	1	D3065-041	LEG ASSEMBLY					
2	2	D3066-1	SPACER					
2	2	D3067-1	END PLATE					
2	2	D3219-1	SUPPORT					
1	1	D3272-1	STEP					
•								
16	16	MS20600AD4W4	RIVET					

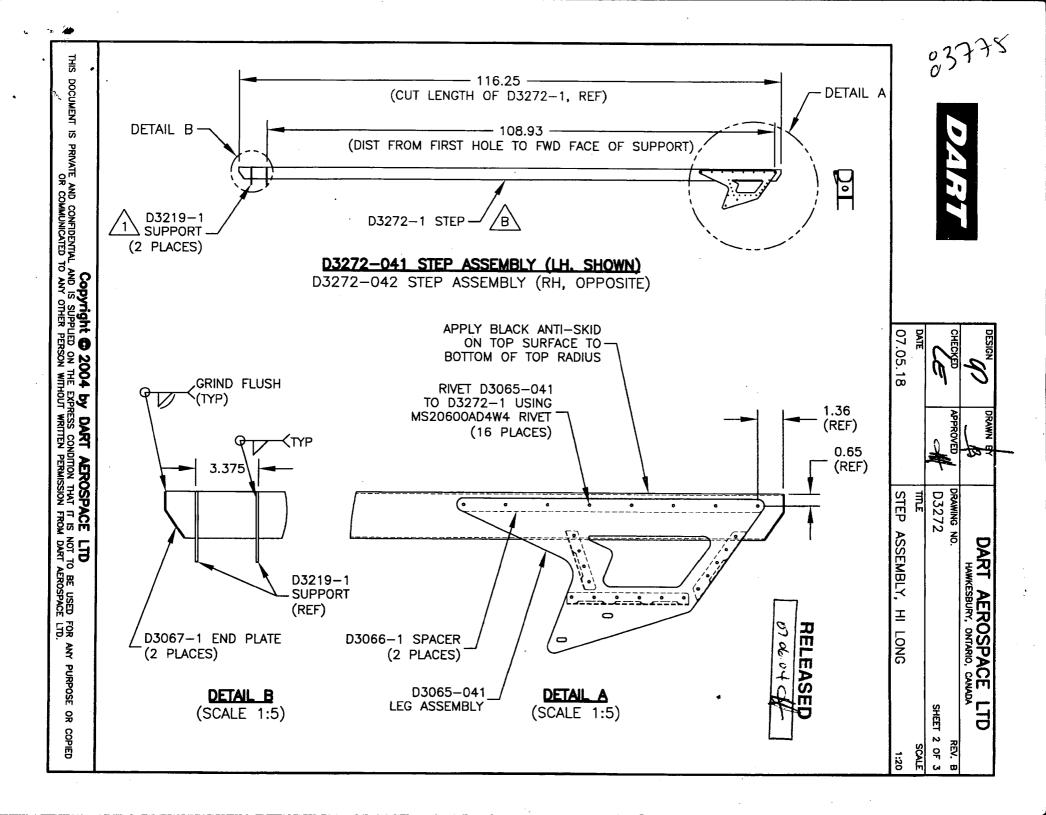
## GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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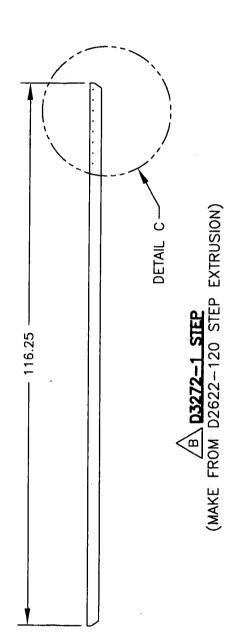
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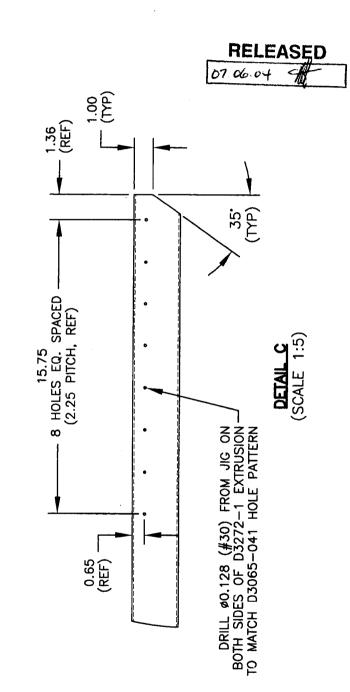
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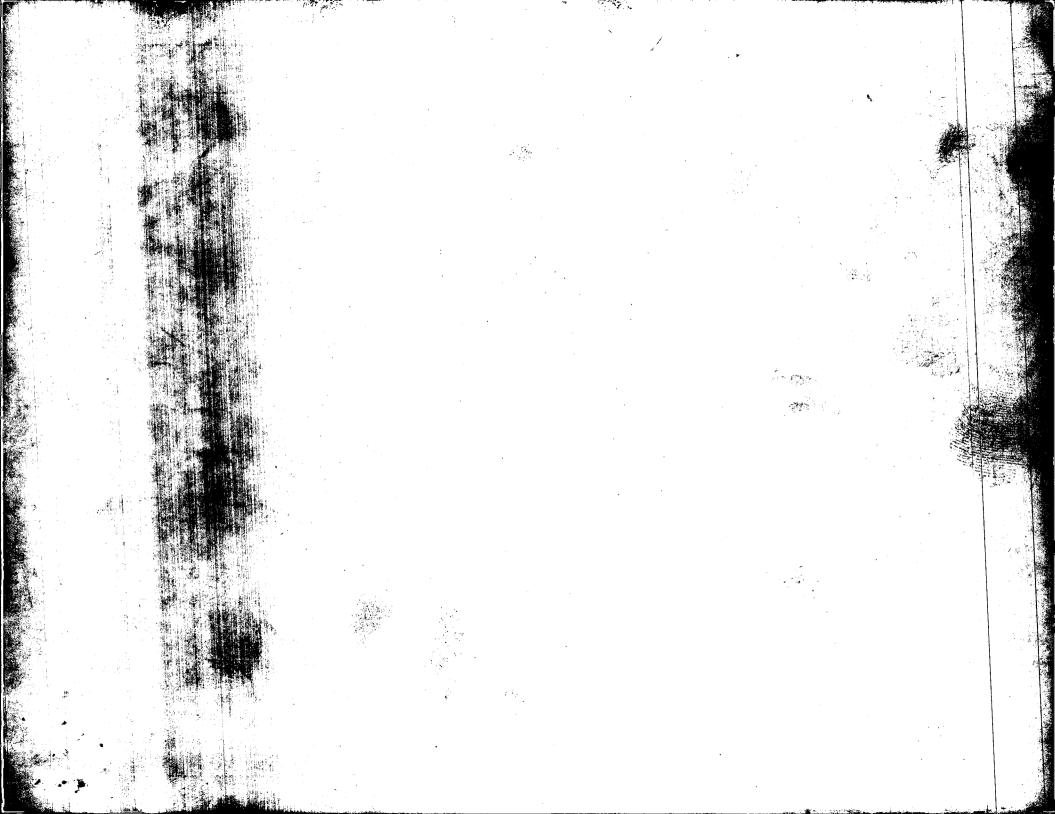
DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
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LE	THE THE	D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20





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## DART AEROSPACE LTD.

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	∫ Oty, -312	Part Number	Description
Х							I	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	Х							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		Х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			Х					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				Х				D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
					Х			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							Х	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
1			L				ļ	D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1						<u> </u>	D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
l		1					ļ	D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
		L	1				<u> </u>	D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	14	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	1-2	*D2618***	BUSHING
4	4	4	4	4	4		Carlotte Annual Control	D2732-030	CUSHION
2	2	1	1	11	1	2	<b>/</b> 2	D2856-400-720	,ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	/ 2	D3235-1	_MOUNTING LUG
						1	1	_D3278-041	SUPPORT ASSEMBLY
							0	AND OF A	BOLT
2	2	2	2	2	2	2	<u> </u>	-AN3-35A	
10	10	2	2	2	2		1000	AN4-11A	BOLT
		4	4	4	4	8	8	_AN4-13A	BOLT
	<u> </u>		ļ			2	2	AN5-36A	BOLT
4	4	4	4	.4	4	4	/4_	_AN960JD10	WASHER
20	20	12	12	12	12	16	/ 16	AN960JD416	WASHER
						4	7 4		-WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	/ 8	MS21042L4	NUT
		L				2	<b>L</b> 2—	-MS21042L5	NUT
	1	1	1	l		1	1 1	*DSI 9410-011	STEP MODIFICATION KIT

<sup>\*</sup>DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G

Date: 08.10.06